

Work Order ID 137540

October 05, 2015 11:51:29 AM

137540

Page 1

Ship today

Item ID: DSI 9722-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Door Prop Upgrade

Start Date: 10/5/2015 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 10/5/2015 Req'd Qty: 2.00 *2* Customer:

Reference:

Approvals: Process Plan: SH Date: 2015-10-05 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9722	A

100 Document Control 0.00
 100
 DC DOCUMENT CONTROL
 Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP DSI9722-011 CHG001

DAS
06
9-89

OCT 05 2015

110 Pick Kit 0.00
 110
 Packaging Memo 0.00
 Packaging

2X DAS
27
9-89

OCT 05 2015

120 QC4- 100% Inspect kits for completeness 0.00
 120
 QC Memo 0.00
 Quality Control

DAS
6
9-89

2
OCT 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 137540***137540***

Page 2

October 05, 2015 11:51:29 AM

Item ID: DSI 9722-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door Prop Upgrade

Start Date: 10/5/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/5/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI9722-011

SHP
10/10/2

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

OCT 05 2015

MCS

SLA 20151005

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

October 05, 2015 11:51:34 AM

Page 1

Work Order ID: 137540

137540

Parent Item: DSI 9722-011

DSI 9722-011

Parent Item Name: Door Prop Upgrade

Start Date: 10/5/2015

Required Date: 10/5/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 15.08.05 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-29		Manufactured	No				Each	14.0000		2			

D3552-29

Door Prop

DAS
6
9-89

Location

ST366

135124

Loc Qty

14

14

Loc Code

B135124

2

DAS
27
9-89

OCT 05 2015

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D139-799 REV. 1 AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D139-799 REV. 8 OR LATER APPROVED REVISION
REF. FAA STC: SR02138SE
REF. EASA STC: 10038656

1.0 PURPOSE

The purpose of this service instruction is to allow customers to substitute their standard D3552-23 Door Props, as part of the D139-799-013 Cargo Door Hinge Kit, with stronger D3552-29 Door Props for cases where the doors are operated with rotors turning and require extra strength to keep them open.

2.0 INSTALLATION AND MAINTENANCE

The D3552-29 Door Prop is installed and maintained in accordance with the instructions for the D3552-23 Door Prop as outlined in IIN-D139-799 and ICA-D139-799, respectively.

3.0 WEIGHT AND BALANCE

This change has negligible effect on weight and balance.

4.0 PARTS LIST

Qty -011	Part Number	Description
X	DSI 9722-011	DOOR PROP UPGRADE KIT
1	D3552-29	DOOR PROP (REPLACES D3552-23)

137540 SH 120151005

A	NEW ISSUE	VS	15.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9722	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DOOR PROP UPGRADE KIT	NTS
DATE	15.07.22	COPYRIGHT ©2015 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	